

MCNDAY <sup>sept</sup> 14

# Work Order ID 52024

September 11, 2009 2:14:42 PM



ASAP.

Page 1

Item ID: D412-698-032

Accept



Setup Start



Revision ID: E

Stop



Item Name: Cabin Door Roller, RH

Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-09-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-032

CHG001

509/09/14

HJ for BG 09/09/14

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

LC 9/9/14 (4)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 509/09/14

(20)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52024**

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Item ID: D412-698-032

Accept



Setup Start



Revision ID: E

Stop



Item Name: Cabin Door Roller, RH

Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-031 ☐ Location: \_\_\_\_\_ ☐ PPP Rev: A

9/14/14

(14x)

SJ

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

09/09/14

09-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 52024

Parent Item: D412-698-032RevE

Parent Item Name: Cabin Door Roller, RH

Comments:

Start Date: 09/14/2009

Required Date: 09/14/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3121-144RevE *lp* Manufactured No



Bracket Assembly

120

Each

15.0000

4.0000

✓



*P09/14/09 (4)*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

43604

5

45086

10

*43609*

D3137-043RevF *lp* Manufactured No



Bracket Assembly

120

Each

48.0000

4.0000

✓



*P09/14/09 (4)*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

29725

4

42192

44

*42192*

D3183-044RevC1 *lp* Manufactured No



Bracket Assembly

120

Each

29.0000

4.0000

✓



*P09/14/09 (4)*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

42194

23

47646

6

*47646*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

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Work Order ID: 52024

Parent Item: D412-698-032RevE

Parent Item Name: Cabin Door Roller, RH

Start Date: 09/14/2009

Required Date: 09/14/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3202-3RevD 1P Cover		Manufactured	No			120	Each	9.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

42516

9

120

Each

48.0000

12.0000

D3674-041RevA 3P

Manufactured

No



BRACKET ASSEMBLY

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

40122

3

42514

39

47645

6

120

Each

84.0000

36.0000

D3675-1RevB 9P

Manufactured

No



SLIDING DOOR BRACKET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

40347

4

42515

80

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



REFERENCE ONLY

DART AEROSPACE LTD.

ICA-D412-698

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**52.18 PARTS LIST - DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

heads

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**52-00-00**

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